

Date: Tuesday, 1/9/2007 4:06:43 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number :	30214		
Estimate Number :	10533		
P.O. Number :	N/A	Part Number :	D2573
This Issue :	1/9/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2573 REV E
First Issue :	N/A	Project Number :	N/A
Previous Run :	30096	Drawing Revision :	E
	Type :	Material :	N/A
	MACHINED PARTS	Due Date :	1/30/2007
Written By :			Qty: 12 Um: Each
Checked & Approved By :			
Comment :	Est: 1 As Per RevE 06-01-27 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
 7075-T7351 8.25X7.75X2.5
 Make from D6101-007 billet for D2573
 Ensure that grain is along 7.75" length
 Batch No: B25355

V12

En 07/01/14 / J.F.

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. B3018 Double check by: J.F.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

En / J.F. 02/01/18

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2573 & D2574

J.F. 07/01/18

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En / J.F. 07/01/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 07/01/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/9/2007 4:06:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 30214

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 07/01/22 12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

sl/

07/01/22 (12)

7.0

POWDER COATING

POWDER COATING



N/ 103141



(12x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-A/ y

07/01/24

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/01/24

(12x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57467*

07/01/24 (12x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

07/01/25

Job Completion



U 07/01/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30214
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440"	0.439	0.440"	0.439		
B	1.745	1.755		1.751"	1.749	1.751"	1.749		
C	3.495	3.505		3.500"	3.498	3.501"	3.498		
D	1.745	1.755		1.751"	1.750	1.751"	1.750		
E	7.990	8.010		7.999	8.000	8.000"	8.003		
F	0.490	0.510		0.503	0.503	0.500"	0.500		
G	0.257	0.262	DT8683	0.258	0.260	0.258	0.257		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.375		
I	0.490	0.510		0.504"	0.504	0.496	0.504		
J	1.174	1.184		1.180"	1.180"	1.178	1.178		
K	0.558	0.578		0.570"	0.570	0.559	0.559		
L	1.174	1.184		1.180"	1.180"	1.178	1.178		
M	1.365	1.375		1.370"	1.370"	1.370	1.370		
N	2.495	2.505		2.500"	2.500"	2.500	2.500		
O	4.119	4.129		4.125"	4.125"	4.126	4.125		
P	0.115	0.135		0.127	0.127	0.126"	0.125		
Q	0.115	0.135		0.135	0.135	0.135"	0.125		
R	0.240	0.260		0.251	0.251	0.250"	0.250		
S	0.115	0.135		0.128	0.128	0.126"	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.232	3.232	3.233"	3.229		
V	0.230	0.250		0.246	0.246	0.241"	0.245		
W	0.115	0.135		0.125	0.125	0.127"	0.125		
X	0.308	0.313		0.310	0.310	0.312"	0.310		
Y	0.760	0.765		0.760	0.760	0.763"	0.760		
Z	0.352	0.372		0.370	0.370	0.362"	0.370		
AA	0.470	0.530		0.500	0.500	0.500"	0.500		
AB	0.615	0.635		0.631"	0.625	0.634"	0.625		
AC	0.053	0.073		0.063	0.063	0.063"	0.063		
AD	0.240	0.260		0.254	0.254	0.248	0.250		
AE	1.500	1.520		1.512	1.510"	1.511"	1.510"		
AF	0.115	0.135		0.135	0.135	0.135"	0.120		
AG	0.240	0.280		0.255"	0.255"	0.260"	0.257		
AH	0.240	0.260		0.254"	0.254"	0.251	0.254		
AI	2.000	2.020		2.001	2.002	2.001"	2.006"		
AJ	0.023	0.043		0.021	0.021	0.025"	0.025"		
Accept/Reject									

Measured by:	J.F. 15.F. (4)
Date:	07/01/18

Audited by:	mk
Date:	07/01/22

Rev.	() Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	30214
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440"	0.440"	0.440"		
B	1.745	1.755		1.751	1.751"	1.751"	1.751"		
C	3.495	3.505		3.500	3.500"	3.500"	3.500"		
D	1.745	1.755		1.751	1.751"	1.751"	1.751"		
E	7.990	8.010		8.001"	7.999"	8.001"	8.002"		
F	0.490	0.510		0.500	0.502"	0.503	0.501"		
G	0.257	0.262	DT8683	0.260"	0.260"	0.260"	0.260"		
H	0.375	0.380	DT8684	0.376"	0.376"	0.376"	0.376"		
I	0.490	0.510		0.504"	0.503"	0.504"	0.505"		
J	1.174	1.184		1.181"	1.181"	1.181"	1.181"		
K	0.558	0.578		0.571"	0.574"	0.571"	0.571"		
L	1.174	1.184		1.181"	1.181"	1.181"	1.181"		
M	1.365	1.375		1.372"	1.378"	1.372"	1.372"		
N	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
O	4.119	4.129		4.124"	4.124"	4.124"	4.124"		
P	0.115	0.135		0.127"	0.127"	0.128"	0.128"		
Q	0.115	0.135		0.135"	0.135"	0.135"	0.135"		
R	0.240	0.260		0.251"	0.251"	0.251"	0.251"		
S	0.115	0.135		0.125"	0.129"	0.126"	0.126"		
T	0.178	0.198		0.188"	0.188"	0.188"	0.188"		
U	3.210	3.250		3.233"	3.233"	3.233"	3.233"		
V	0.230	0.250		0.242"	0.240"	0.240"	0.241"		
W	0.115	0.135		0.126"	0.124"	0.127"	0.125"		
X	0.308	0.313		0.312"	0.312"	0.312"	0.312"		
Y	0.760	0.765		0.762"	0.763"	0.763"	0.763"		
Z	0.352	0.372		0.365"	0.370"	0.370"	0.370"		
AA	0.470	0.530		0.500"	0.500"	0.500"	0.500"		
AB	0.615	0.635		0.632"	0.634"	0.634"	0.632"		
AC	0.053	0.073		0.063"	0.063"	0.063"	0.063"		
AD	0.240	0.260		0.248"	0.244"	0.248"	0.244"		
AE	1.500	1.520		1.511"	1.514"	1.512"	1.513"		
AF	0.115	0.135		0.135"	0.121"	0.121"	0.121"		
AG	0.240	0.280		0.255"	0.267"	0.267"	0.270"		
AH	0.240	0.260		0.251"	0.251"	0.251"	0.252"		
AI	2.000	2.020		2.003"	2.007"	2.002"	2.003"		
AJ	0.023	0.043		0.025"	0.025"	0.025"	0.025"		
Accept/Reject									

Measured by: J.F.
Date: 07/01/19

Audited by: [Signature]
Date: 07/01/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]

DART AEROSPACE LTD	Work Order: 30214
Description: Saddle, Aft Outboard	Part Number: D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

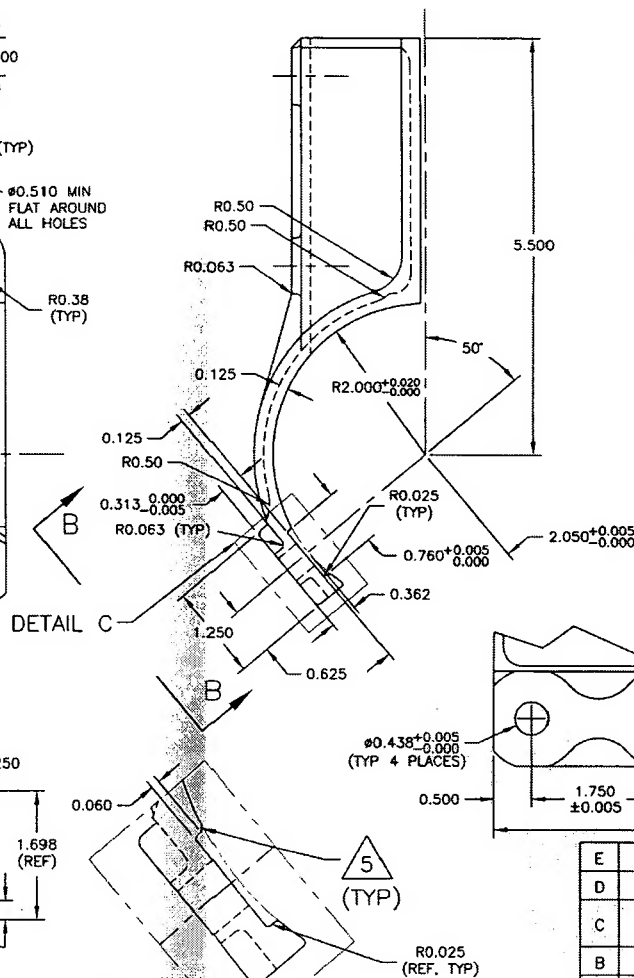
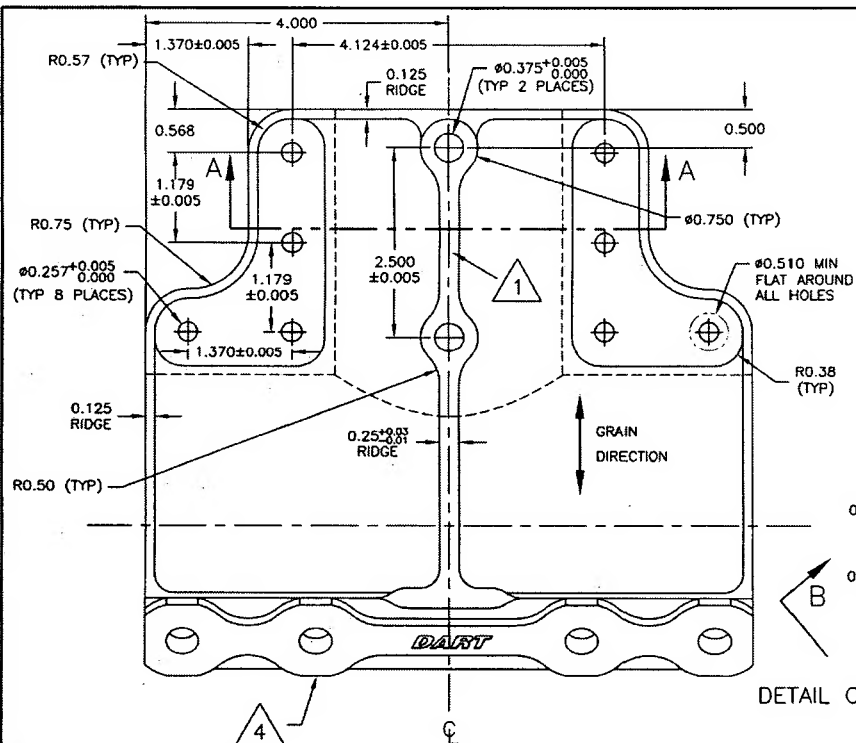
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	.438	.438	.438	.438		
B	1.745	1.755		1.755	1.755	1.755	1.755		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.755	1.755	1.755	1.755		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.180	1.180		
K	0.558	0.578		.560	.560	.560	.560		
L	1.174	1.184		1.179	1.179	1.180	1.180		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.120	4.120	4.120	4.120		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.120	.120	.120	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.250	3.250	3.250	3.251		
V	0.230	0.250		.245	.245	.244	.244		
W	0.115	0.135		.120	.120	.120	.125		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.750	.750	.750	.750		
Z	0.352	0.372		.360	.360	.360	.360		
AA	0.470	0.530		.470	.470	.470	.470		
AB	0.615	0.635		.620	.621	.621	.621		
AC	0.053	0.073		.070	.070	.070	.070		
AD	0.240	0.260		.250	.251	.260	.260		
AE	1.500	1.520		1.511"	1.512"	1.501	1.511		
AF	0.115	0.135		.120	.125	.122	.122		
AG	0.240	0.280		.250	.251	.251	.251		
AH	0.240	0.260		.250	.245	.245	.246		
AI	2.000	2.020		2.002"	2.001"	2.001	2.001		
AJ	0.023	0.043		.033	.037	.037	.036		
Accept/Reject									

Measured by: J.F. 185
Date: 02/01/21

Audited by: ml
Date: 07/01/22






Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

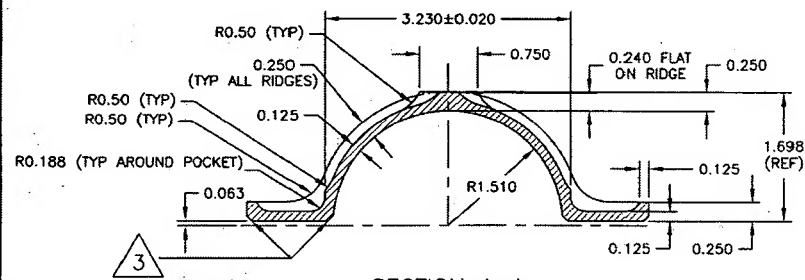
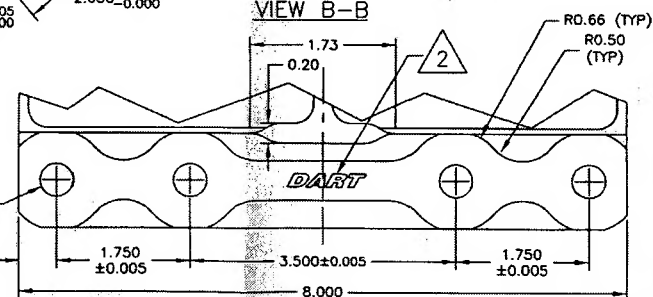


NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED




- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE PART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C) |

VIEW B-B



SECTION A-A

DETAIL C
SCALE 4:3

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN		 DART AEROSPACE LTD. HANMUSEBURY, ONTARIO, CANADA
DS	DRAWN BY PH	
CHECKED 	APPROVED 	DRAWING NO. D2573
DATE 05.07.13		TITLE OUTER AFT SADDLE
		REV. SHEET 1 OF 1 SCALE

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